Work Order ID 72166

Tuesday, July 19, 2011 1:51:41 PM

Item ID: D2530 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Handle Weldment

Start Date: 7/19/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 7/25/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** X **Date:** 11-07-11 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2530	Rev B								
100	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	1-Cut to length as per Dwg D2536 2-Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00							
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: 117884	0.00							
Large Fab	Small Fab								
Large Fab	**Memo**	0.00							
	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

11/07/21 10

11 07 21 10

QC 11.08.07

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Stop

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00				11.08.10			
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00				10			
Quality Control									
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	MK115128								
Powder Coating	**Memo**	0.00				10			
	START TIME: 8:15AM OVEN TEMPERATURE: 320°F FINISH TIME: 8:45A								

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Work Order ID 72166

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Revision ID:

Item Name: Handle Weldment

Start Date: 7/19/2011 **Start Qty:** 10.00 **Cust Item ID:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 506	0.00							
Packaging	**Memo**	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10 X Ø MA 11/08/11

CC 11/8/12 (10)

CK 11/08/12

11/08-12 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 1:51:47 PM

Work Order ID: 72166

Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 7/19/2011 **Required Date:** 7/25/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	212.5281	2.9145	30.67895			
304 RD Tube .750 x .049W													

Location	Loc Qty	Loc Code
MAT017	212.52813	
109314	9.333	
111619	3	
112187	4	
112800	11	
114852	2.75	
116108	3	
116720	1.833	
117030	3.09263	
117797	0.75	
117983	173.7695	

30.6785

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2534		Manufactured	No			120	Each	22.0000	2	20			
Lock Plate													

Location	Loc Qty	Loc Code
WA	22	
70996	22	

20

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NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
B WILLIAMS	PH	
CHECKED	APPROVED	DRAWING NO. D2530 REV. B SHEET 1 OF 1
DATE 04.12.14		TITLE HANDLE WELDMENT SCALE

A	96.06.18	NEW ISSUE
B	04.12.14	UPDATE NOTES AND DIMENSIONS

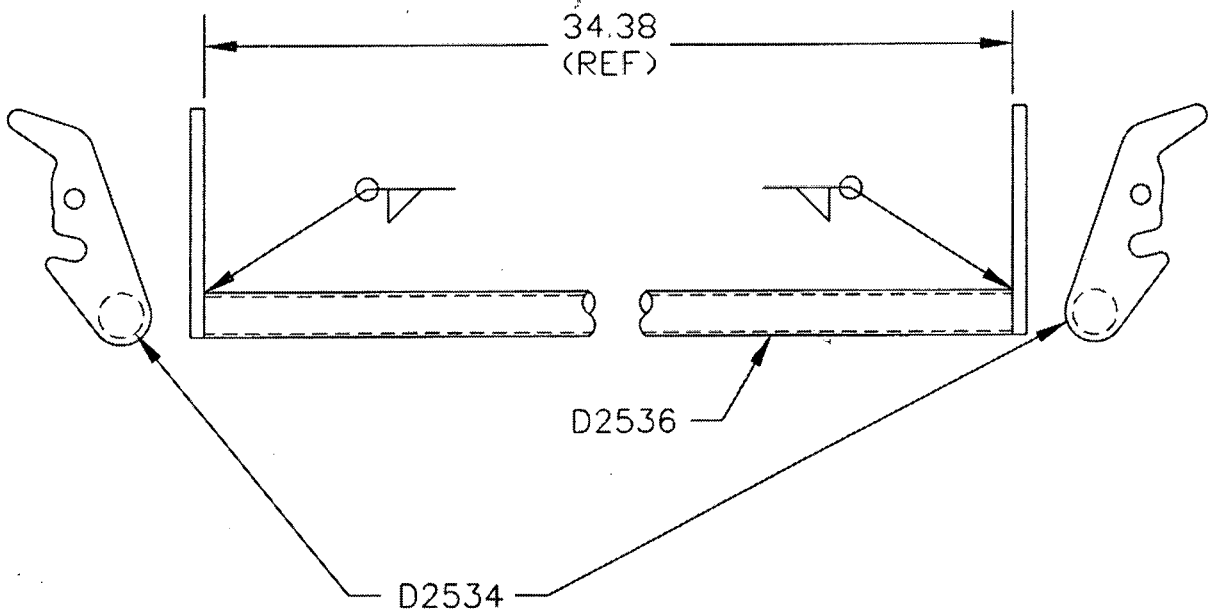
RELEASED
04.12.16

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72466

#110719



D2530 HANDLE WELDMENT

1) WELD PER DART QSI 004
2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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